Radilon® A RV250KB 856 BR

Radici Group High Performance Polymers - Polyamide 66

General Information

Product Description

PA66 25% glass fiber reinforced injection moulding grade. Heat stabilized. Natural brown colour.

Suitable for parts requiring medium stiffness, intended for use in contact with oil and grease at high temperature.

General		
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight	
Additive	• Heat Stabilizer	
Features	• Grease Resistant • Heat Stabilized	• Medium Stiffness • Oil Resistant
Uses	• Automotive Applications	
Agency Ratings	• EU 2011/65/EC	
RoHS Compliance	• RoHS Compliant	
Appearance	• Brown	
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA66-T GF25	

Properties [1]

Physical	Dry	Conditioned	Unit	Test Method
Density	1.32	--	g/cm³	ISO 1183
Molding Shrinkage [2]				ISO 294-4
Across Flow	1.0	--	%	
Flow	0.40	--	%	
Water Absorption				ISO 62
Saturation, 73°F, 0.0787 in	7.4	--	%	
Water Absorption				ISO 62
Equilibrium, 73°F, 0.0787 in, 50% RH	2.0	--	%	
Viscosity Index - Sulfuric Acid	3600	--	in³/lb	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	1.16E+6	841000	psi	ISO 527-1/1A/1
Tensile Stress (Break)	24700	16700	psi	ISO 527-2/1A/5
Tensile Strain (Break)	3.8	6.0	%	ISO 527-2/1A/5
Flexural Modulus [3]	1.04E+6	609000	psi	ISO 178
Flexural Stress [3]	36300	22500	psi	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°F	4.3	--	ft·lb/in²	
73°F	5.2	6.2	ft·lb/in²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F	26	--	ft·lb/in²	
73°F	31	38	ft·lb/in²	
Notched Izod Impact Strength				ISO 180/1A
73°F	4.6	5.7	ft·lb/in²	

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Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/Bf
66 psi, Unannealed	482	--	°F	
Deflection Temperature Under Load				ISO 75-2/Af
264 psi, Unannealed	446	--	°F	
Vicat Softening Temperature	482	--	°F	ISO 306/B50
Melting Temperature [4]	500	--	°F	ISO 11357-3
Aging	**Dry**	**Conditioned**	**Unit**	**Test Method**
Change in Tensile Stress				ISO 2578
284°F, 20000 hr	50	--	%	
338°F, 5000 hr	50	--	%	
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity [5]	1.0E+12	1.0E+10	ohms	IEC 62631-3-2
Volume Resistivity [5]	1.0E+15	1.0E+13	ohms·cm	IEC 62631-3-1
Comparative Tracking Index				IEC 60112
Solution A	600	--	V	
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Burning Rate (0.118 in)	0.0	--	in/min	ISO 3795
Flame Rating	HB	--		UL 94
Glow Wire Flammability Index				IEC 60695-2-12
0.04 in	1200	--	°F	
0.08 in	1250	--	°F	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.04 in	1250	--	°F	
0.08 in	1290	--	°F	

Processing Information

Injection	Dry	Unit
Drying Temperature - Desiccant Dryer	176	°F
Drying Time - Desiccant Dryer	2.0 to 4.0	hr
Dew Point - Desiccant Dryer	< -4	°F
Suggested Max Moisture	0.10	%
Processing (Melt) Temp	536 to 572	°F
Mold Temperature	176 to 212	°F
Injection Rate	Moderate-Fast	

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 300°C Melt Temperature/ 90°C Mold Temperature/ 60 MPa Cavity Pressure

[3] 0.079 in/min

[4] 10°C/min

[5] 500V